

Date: Thursday, 22/01/2009 8:14:24 AM
 User: Melanie Fauteux

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	FWD BLADE FOLD ASSY WELDMENT
Job Number :	45052		
Estimate Number :	13418		
P.O. Number :		Part Number :	PB674300107
This Issue :	22/01/2009	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	B6743001 P.5
First Issue :	//	Project Number :	N/A
Previous Run :	45051	Drawing Revision :	B1
	Type :	Material :	
	LARGE FAB ASSY	Due Date :	28/02/2009
Written By :		Qty:	3 Um: Each
Checked & Approved By :	MF 09-01-22		
Comment :	Est Rev:A 08-06-25 new issue DD verified by:ec		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PB674300147	Base Assembly
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Base Assembly

batch:- 45027

MF 09-03-02

2.0	PB6743001205	Outer Tube
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Outer Tube

batch:- 41485

MF 09-03-02

3.0	PB6743001197	Outer Tube
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Outer Tube

batch:- 41483

MF 09-03-02

4.0	PB6743001211	Square Tubing
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Comment: Qty.: 6.0000 Each(s)/Unit Total : 18.0000 Each(s)

Square Tubing

batch:- B44989

MF 09-03-02

5.0	PB6743001209	Square Tubing
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Square Tubing

batch:- B43073

MF 09-03-02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD BLADE FOLD ASSY WELDMENT

Job Number: 45052

Part Number: PB674300107

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PB6743001201

Square Tubing



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)
Square Tubing
batch:- B 41484

MF 09-03-02

7.0

PB6743001203

Square Tube



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)
Square Tube
batch:- 41907

MF 09-03-02

8.0

PB6743001207

Square Tube



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)
Square Tube
batch:- 43199

MF 09-03-02

9.0

PB6743001219

Angled Male Eye



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)
Angled Male Eye
batch:- 41908

MF 09-03-02

10.0

D34405

Contoured Detent Clip Base (Supersedes B



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)
Contoured Detent Clip Base
batch:- 41203

MF 09-03-02

11.0

D34407

Detent Clip Base (Supersedes B67-43001-2



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)
Detent Clip Base
batch:- 41204 x 2, B 41455 x 1

MF 09-03-02

12.0

D344015

Contoured Male Eye (Supersedes B67-43001



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)
Contoured Male Eye
batch:- 41202 x 1, B 41453 x 2

MF 09-03-02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Date: Thursday, 22/01/2009 8:14:24 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD BLADE FOLD ASSY WELDMENT

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Part Number: PB674300107

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- assemble parts on jig DT8813 and weld as per dwg PB67-43001

*** ensure no burn thru after welding in tube -205 and -197 only where bushing -265 ***

lp 09.03.06

SP 09.03.06 **(X3)**

14.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 09-03-06

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/03/06 **(43)**

16.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

mask inside of D3440-5, D3440-7 and D3440-15 prior to paint*

Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

*3:45
320 OF
4:15*

M18144

M-L 09/03/06 **(3X)**

17.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SAD 09-03-07

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

*Mr Frank finishing
to be assemble on - 01*

MF 09-03-09

19.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/03/09

Job Completion



MF 09-03-09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

1.8 NO PAINT THIS
AREA ALL AROUND - 315
- 3 PLACES

